

Work Order ID 57223

March 30, 2010 10:43:44 AM

Page 1

Item ID: D3573-3

Revision ID:

Item Name: Adapter

Start Date: 30/03/2010 Start Qty: 10.00

Required Date: 08/04/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Accept

Tooling:

SPC (Y/N):

Date:

Date:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3573	Rev A								
100	BAND SAW	0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 3.500" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA673 and Dwg D3573								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									



SL 10/03/31

10 6

SL 10/04/04

10 6

SL 10/04/04

10 6

10-03-30

Work Order ID 57223

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Item ID: D3573-3

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Start Date: 30/03/2010 Start Qty: 10.00

Required Date: 08/04/2010 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

DJP 10/04/05

10 *0*

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

ej 10/04/06

(X10) 0

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

=> 10/04/07

X10 0

START TIME:

3:45pm

FINISH TIME:

OVEN TEMPERATURE:

320°C

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Accept

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

170

Identify as per dwg & Stock Location: 244

0.00

Packaging

Packaging

Memo

0.00

180

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/04/12

ME 10-4-9

Picklist Print

March 30, 2010 10:43:43 AM

Work Order ID: 57223

Parent Item: D3573-3

Parent Item Name: Adapter

Comments: IPP Rev:A New Issue 07-01-29 JLM

Start Date: 30/03/2010

Required Date: 08/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50 0		Purchased	No			100	f	27.5923	3.0737			



6061-T6 Bar .500 x 2.50



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT02

103435

104366

27.59231579

1.06

26.5323158

3.0737 8.8 10/03/31

DART AEROSPACE LTD		Work Order:	
Description: Adapter		Part Number:	D3573-3
Inspection Dwg: D3573	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

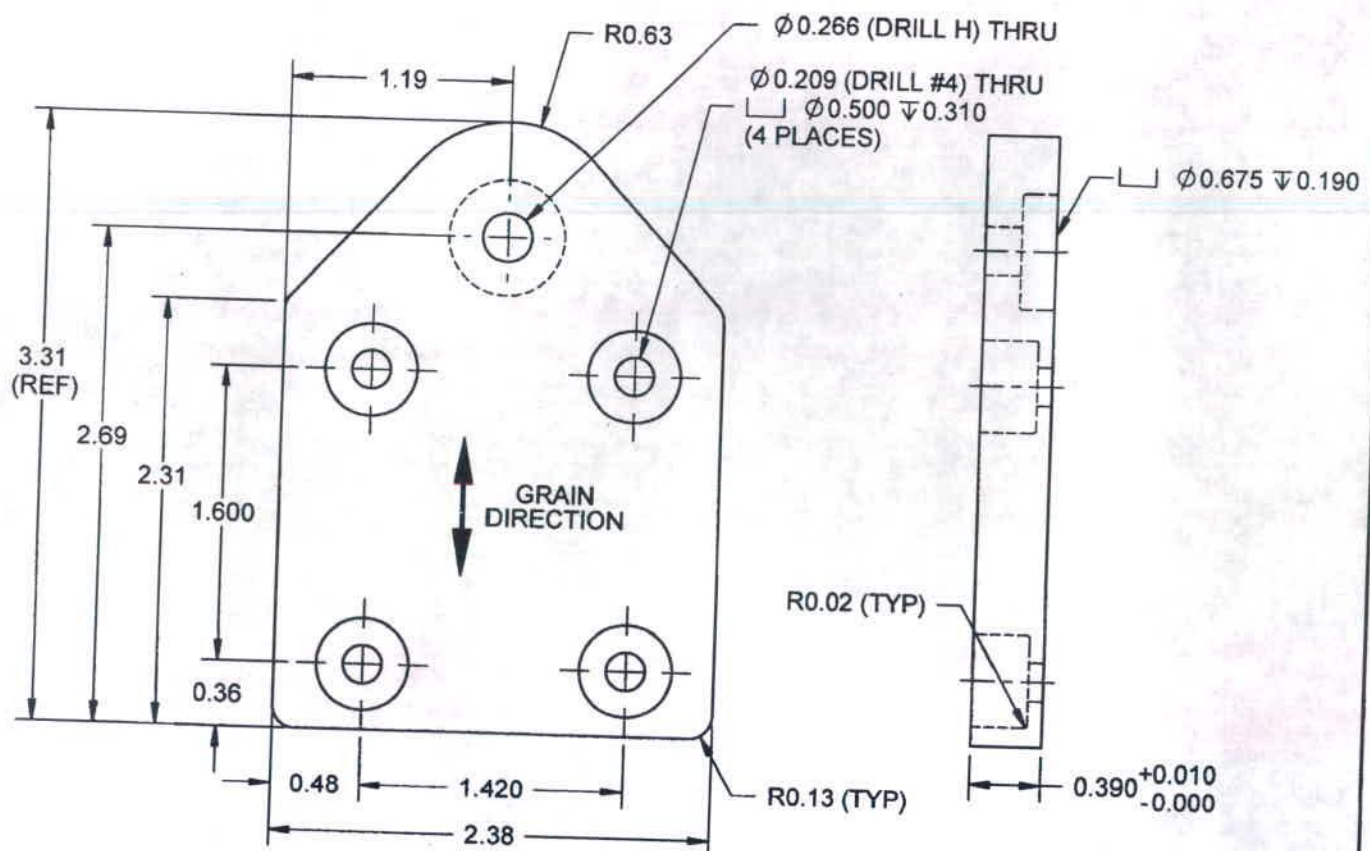
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	+/-0.030	3.310	✓			
2.69	+/-0.030	2.688	✓			
2.31	+/-0.030	2.310	✓			
1.600	+/-0.005	1.600	✓			
0.36	+/-0.030	.358	✓			
1.19	+/-0.030	1.188	✓			
2.38	+/-0.030	2.373	✓			
1.420	+/-0.010	1.420	✓			
0.48	+/-0.030	.479	✓			
R0.63	+/-0.030	.630	✓			
R0.13	+/-0.030	.130	✓			
R0.02	+/-0.030	.015	✓			
Ø0.209	+0.005/-0.001	.211	✓			
Ø0.266	+0.006/-0.001	.267	✓			
0.390	+0.010/-0.000	.392	✓			
Ø0.675 x 0.190	+/-0.010	.673x.188	✓			
Ø0.500 x 0.310	+/-0.010	.495x.309	✓			

Measured by: <u>SL</u>	Audited by: <u>DJP</u>	Prototype Approval:	N/A
Date: <u>10/04/04</u>	Date: <u>10/04/05</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.04	New Issue	KJ/JLM	<u>[Signature]</u>

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	SHEET 2 OF 4
DATE 07.02.19	TITLE ADAPTER	SCALE 1:1	

RELEASED
07.04.02**D3573-3 ADAPTER****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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